

Work Order ID 87109

87109

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Item ID: D412-698-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cabin Door Roller, RH
 Start Date: 7/10/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/31/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Q Date: 12-07-12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								

100 DOCUMENT CONTROL 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D412-698-012 CHG003
 DAS 16 12/08/12 AB
 MCT 12/08/10 (2)

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging
 SQ 2 12/08/10

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00
 Quality Control
 DAS 16 12/08/12
 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				(20)			DK6029
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-012 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 12/08/23

ME
12-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 87109

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 7/10/12

Required Date: 8/31/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<u>D3121-141</u> Bracket Assembly		Manufactured	No			110	Each	16.0000	3	6	✓		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST235		16							
				83457		5							
				84414		11							
<u>D3121-144</u> Bracket Assembly		Manufactured	No			110	Each	7.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST235		6							
				84412		6							
				ST235A		1							
				75032		1							
<u>D3137-043</u> Bracket Assembly		Manufactured	No			110	Each	10.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST235B		10							
				79734		2							
				83467		8							
<u>D3183-044</u> Bracket Assembly		Manufactured	No			110	Each	2.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST		-4							
				ST235B		6							
				82689		2							

5x B 85488 SD

1x 84414 ✓

2x 84412 2

1x 75032

83467

12/08/10

85996

MF 12-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 87109

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 7/10/12

Required Date: 8/31/12

Start Qty: 2.00

Required Qty: 2.00

D3199-1
Bracket

Manufactured No

110 Each 102.0000

9

18

JB

Location

Loc Qty

Loc Code

ST	30	
85467	30	
ST236	77	
78618	2	
83267	63	83267
83860	7	
ST236A	-5	

D3202-1
Cover

Manufactured No

110 Each 23.0000

1

2

JB 12/08/10

Location

Loc Qty

Loc Code

ST241A	23	
70294	2	
82663	7	82663
83506	14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01

